

Date: Monday, 2/27/2006 4:18:01 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STRUT		
Job Number	: 25972					
Estimate Number	: 10275					
P.O. Number	: N/A			Part Number	: D2565103	
This Issue	: 2/27/2006		S.O. No.	: N/A		
Prsht Rev.	: NC			Drawing Number	: D2565 REV E	
First Issue	: N/A			Project Number	: N/A	
Previous Run	: 24274			Drawing Revision	: E	
Written By	: <u>SEE DOCUMENT BELOW</u>			Material	: N/A	
Checked & Approved By	: <u>JG</u> 06.02.28			Due Date	: 3/20/2006	
Comment	: Est: F02.04.46 Added dwg Rev.C1 NG			Qty:	20	Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0750W049	304 RD Tube .750 x .049W	
		Comment: Qty.: 1.5934 f(s)/Unit Total : 31.8675 f(s) 304 RD TUBE .750 X.49W 304/316/318-2B Seamless Tubing, 3/4" O.D. x 0.049" wall (M304TR0750W049)	
		(1) Batch M100138 (2) M17060	SD 06/03/06
2.0	BRAKE NC	NC BRAKE	
		Comment: BRAKE NC Punch to length as per Dwg D2565 using DT8313	SD 06/03/06
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Drill hole open to .3125 Ø as per Dwg D2565 (one end only) 2-Deburr	P10 SD 06/03/08
4.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	06-07-09
5.0	POWDER COATING	POWDER COATING	
		Comment: POWDER COATING Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3	DL 06/03/22 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-03-09	3	hole size AS per Dwg is .316 (detn.1 C)	JM			JM	06-03-09

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/03/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



P0 8/3/20 (20)

Comment: INSPECT POWDER COAT

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 185

P0 6/3/20 (20)

8.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

P0 06/03/20 (20)

Job Completion



06-03-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



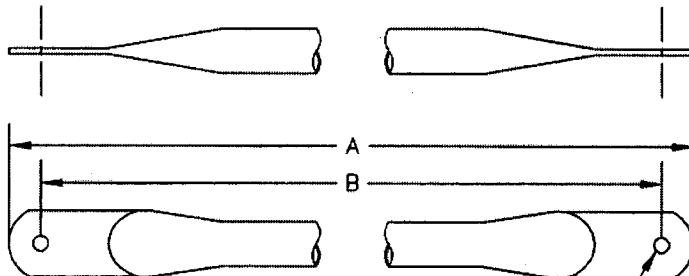
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
		D2565	SHEET 1 OF 1

DATE 04.05.05 TITLE STRUT SCALE 1:3

RELEASED
04.05.05

A	96.05.03	NEW ISSUE
B	97.03.15	CORRECT D2565-111 DIM. A
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)
D	02.06.05	ADD -3XX PARTS; ADD FINISH
E	04.05.05	ADD D2565-401-411; RMV ANGLE D



DIA 0.257 TO BE PUNCHED
"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

GENERAL NOTES

1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL

(REF DART SPEC. M304TR0.750W0.049)

ENSURE SEAMLESS TUBE IS USED

2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 WITHOUT NOTICE

3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES

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ENGINEERING

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SUBJECT TO AMENDMENT

WORK ORDER

NO. 25972

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